

**CRITERIA HAVING NONCOMPLIANCES  
SUPPLEMENT TO THE FY 2003 ACSEP REPORT**

**Prepared by  
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## TABLE OF CONTENTS

INTRODUCTION.....	1
Table 1. – Systemic Noncompliances .....	2
Table 2. – Isolated Noncompliances .....	6
Table 3. – CFR-Based Noncompliances .....	9
Table 4. – Systemic Noncompliances at TSO Facilities .....	10
Table 5. – Isolated Noncompliances at TSO Facilities .....	13
Table 6. – CFR-Based Noncompliances at TSO Facilities .....	14
Table 7. – Systemic Noncompliances at PC Facilities .....	15
Table 8. – Isolated Noncompliances at PC Facilities .....	17
Table 9. – CFR-Based Noncompliances at PC Facilities .....	19
Table 10. – Systemic Noncompliances at PMA Facilities.....	20
Table 11. – Isolated Noncompliances at PMA Facilities.....	23
Table 12. – CFR-Based Noncompliances at PMA Facilities.....	25

## **INTRODUCTION**

The following tables provide the specific criteria data collected during FY 2003 ACSEP evaluations conducted at production approval holders. Tables 1 through 3 present data from all approval types combined. The remainder of the tables present data for the particular approval type specified.

*Table 1. – Systemic Noncompliances*

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of Total Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
401	Work instructions control manufacturing process	21	6%	11%
413	Receiving inspection	20	6%	10%
602	Initial and periodic evaluation of suppliers	18	5%	10%
508	Tool and gauge calibration	16	5%	8%
402	Special processes identified and defined	15	4%	9%
427	Part marking	14	4%	7%
116	Internal audit	12	3%	7%
409	Inspection methods	12	3%	6%
416	Control of shelf life materials	12	3%	7%
405	Manufacturing records	11	3%	6%
530	Nonconforming products controlled	11	3%	6%
601	Use of approved suppliers	10	3%	5%
206	Minor design changes	9	3%	5%
201	Drawing control system	8	2%	4%
202	Technical data file	8	2%	4%
117	Internal audit results reported to management	7	2%	4%
428	Shipping of conforming products	6	2%	3%
424	Segregation of parts in storage	5	1%	3%
426	Storage of conforming parts	5	1%	3%
513	Test procedures controlled	5	1%	3%
529	MRB	5	1%	3%
102	Operating within production limitations	4	1%	2%
105	Quality manual in use	4	1%	2%
204	Design change approval	4	1%	2%
410	Inspection marking	4	1%	2%
411	Issuance of stamps	4	1%	2%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of Total Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
414	Receiving inspection records	4	1%	2%
420	Traceability to split lots	4	1%	3%
422	Prevention of part damage/contamination	4	1%	2%
521	NDI operators qualified	4	1%	3%
607	Delegation of inspection to supplier	4	1%	4%
107	Tags, forms, etc. described	3	1%	2%
314	Verification prior to use	3	1%	3%
415	Verification of shelf life materials	3	1%	2%
425	Incorporation of design changes	3	1%	2%
507	Tool and gauge accuracy	3	1%	2%
528	NDI records	3	1%	2%
614	Quality review of purchase documents	3	1%	2%
103	Policy document describes organization	2	1%	1%
205	Design changes appropriately documented	2	1%	1%
207	Major design changes	2	1%	1%
311	Change documentation and approval	2	1%	2%
313	Software security	2	1%	2%
404	Special process operator qualifications	2	1%	1%
412	Environmental controls	2	1%	2%
418	Traceability of components	2	1%	1%
501	Statistical sampling plans	2	1%	1%
509	Calibration standards	2	1%	1%
534	Corrective action based on MRB	2	1%	1%
603	Approval of supplier's quality manual	2	1%	2%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of Total Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
104	Policy document reviewed	1	1%	1%
106	Quality system data and changes submitted to FAA	1	1%	1%
203	Management review of design changes	1	1%	1%
301	Software Configuration Management Plan	1	1%	1%
302	Configuration Index Document	1	1%	1%
307	Software identification	1	1%	1%
308	Programmed media handling/storage	1	1%	1%
310	Software Configuration Management Plan	1	1%	1%
406	Special process equipment calibrated	1	1%	1%
408	Identification of inspection stations	1	1%	1%
417	Incoming material segregated	1	1%	1%
419	Traceability to raw material	1	1%	1%
423	Control of cleaners	1	1%	1%
430	Documents to importing country	1	1%	1%
431	Airworthiness approvals	1	1%	1%
510	Protection of tools and gauges	1	1%	1%
511	SOT gauges	1	1%	1%
516	Test records	1	1%	1%
520	NDI processes controlled	1	1%	1%
522	NDI procedures available	1	1%	1%
531	MRB major changes FAA approved	1	1%	1%
605	Use of other party registered suppliers	1	1%	2%
609	Control of direct ship suppliers	1	1%	2%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of Total Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
611	Flow down of data to suppliers	1	1%	1%
612	Control of supplier design	1	1%	1%
618	Control of parts from associate facilities	1	1%	1%
619	Consortium activities	1	1%	2%
706	Logbooks properly annotated	1	1%	2%

*Table 2. – Isolated Noncompliances*

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of Total Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
508	Tool and gauge calibration	10	7%	5%
530	Nonconforming products controlled	9	7%	5%
202	Technical data file	9	7%	5%
401	Work instructions control manufacturing process	8	6%	4%
405	Manufacturing records	7	5%	4%
409	Inspection methods	6	4%	3%
406	Special process equipment calibrated	6	4%	4%
413	Receiving inspection	5	4%	3%
206	Minor design changes	5	4%	3%
602	Initial and periodic evaluation of suppliers	4	3%	2%
601	Use of approved suppliers	4	3%	2%
416	Control of shelf life materials	4	3%	2%
501	Statistical sampling plans	3	2%	2%
402	Special processes identified and defined	3	2%	2%
204	Design change approval	3	2%	2%
611	Flow down of data to suppliers	2	1%	1%
607	Delegation of inspection to supplier	2	1%	2%
510	Protection of tools and gauges	2	1%	1%
428	Shipping of conforming products	2	1%	1%
426	Storage of conforming parts	2	1%	1%



<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of Total Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
414	Receiving inspection records	2	1%	1%
411	Issuance of stamps	2	1%	1%
404	Special process operator qualifications	2	1%	1%
403	New or changed processes approved	2	1%	1%
314	Verification prior to use	2	1%	2%
205	Design changes appropriately documented	2	1%	1%
201	Drawing control system	2	1%	1%
107	Tags, forms, etc. described	2	1%	1%
106	Quality system data and changes submitted to FAA	2	1%	1%
609	Control of direct ship suppliers	1	1%	2%
534	Corrective action based on MRB	1	1%	1%
533	MRB major or minor determination	1	1%	1%
527	NDI tanks and solutions	1	1%	1%
526	NDI test samples	1	1%	1%
522	NDI procedures available	1	1%	1%
520	NDI processes controlled	1	1%	1%
519	Flight check-off form	1	1%	2%
514	Organizational review of test procedures	1	1%	1%
512	Tool control of NDI equipment	1	1%	1%
504	SPC control limits	1	1%	1%
427	Part marking	1	1%	1%
423	Control of cleaners	1	1%	1%

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of Total Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
420	Traceability to split lots	1	1%	1%
417	Incoming material segregated	1	1%	1%
412	Environmental controls	1	1%	1%
312	Software problem reporting	1	1%	1%
306	Software Development Environment	1	1%	1%
207	Major design changes	1	1%	1%
117	Internal audit results reported to management	1	1%	1%
112	Feedback from users	1	1%	1%
103	Policy document describes organization	1	1%	1%
102	Operating within production limitations	1	1%	1%

Table 3. – CFR-Based Noncompliances

Criteria	Description	Number of CFR-Based Noncompliances	Percent of Total CFR-Based Noncompliances	Percent with Procedures in Place
427	Part marking	3	11%	2%
408	Identification of inspection stations	3	11%	2%
402	Special processes identified and defined	3	11%	2%
202	Technical data file	2	7%	1%
109	Facility relocations reported	2	7%	2%
704	MMF work performed IAW approved data	1	4%	2%
602	Initial and periodic evaluation of suppliers	1	4%	1%
534	Corrective action based on MRB	1	4%	1%
533	MRB major or minor determination	1	4%	1%
529	MRB	1	4%	1%
519	Flight check-off form	1	4%	2%
513	Test procedures controlled	1	4%	1%
508	Tool and gauge calibration	1	4%	1%
425	Incorporation of design changes	1	4%	1%
413	Receiving inspection	1	4%	1%
409	Inspection methods	1	4%	1%
401	Work instructions control manufacturing process	1	4%	1%
207	Major design changes	1	4%	1%
206	Minor design changes	1	4%	1%

*Table 4. – Systemic Noncompliances at TSO Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of TSO Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
508	Tool and gauge calibration	5	6%	15%
530	Nonconforming products controlled	5	6%	15%
402	Special processes identified and defined	4	5%	19%
413	Receiving inspection	4	5%	12%
426	Storage of conforming parts	4	5%	12%
102	Operating within production limitations	3	3%	9%
116	Internal audit	3	3%	9%
411	Issuance of stamps	3	3%	9%
422	Prevention of part damage/contamination	3	3%	9%
427	Part marking	3	3%	9%
107	Tags, forms, etc. described	2	2%	6%
202	Technical data file	2	2%	6%
409	Inspection methods	2	2%	6%
412	Environmental controls	2	2%	8%
416	Control of shelf life materials	2	2%	7%
420	Traceability to split lots	2	2%	8%
501	Statistical sampling plans	2	2%	8%
529	MRB	2	2%	6%
602	Initial and periodic evaluation of suppliers	2	2%	6%
614	Quality review of purchase documents	2	2%	8%
103	Policy document describes organization	1	1%	3%
104	Policy document reviewed	1	1%	3%
105	Quality manual in use	1	1%	3%
106	Quality system data and changes submitted to FAA	1	1%	3%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of TSO Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
117	Internal audit results reported to management	1	1%	3%
201	Drawing control system	1	1%	3%
203	Management review of design changes	1	1%	3%
204	Design change approval	1	1%	3%
205	Design changes appropriately documented	1	1%	3%
206	Minor design changes	1	1%	3%
307	Software identification	1	1%	5%
311	Change documentation and approval	1	1%	5%
314	Verification prior to use	1	1%	5%
401	Work instructions control manufacturing process	1	1%	3%
404	Special process operator qualifications	1	1%	6%
405	Manufacturing records	1	1%	3%
406	Special process equipment calibrated	1	1%	4%
410	Inspection marking	1	1%	3%
414	Receiving inspection records	1	1%	3%
415	Verification of shelf life materials	1	1%	3%
417	Incoming material segregated	1	1%	3%
418	Traceability of components	1	1%	3%
428	Shipping of conforming products	1	1%	3%
431	Airworthiness approvals	1	1%	3%
507	Tool and gauge accuracy	1	1%	3%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of TSO Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
513	Test procedures controlled	1	1%	3%
516	Test records	1	1%	8%
521	NDI operators qualified	1	1%	5%
531	MRB major changes FAA approved	1	1%	4%
534	Corrective action based on MRB	1	1%	3%
601	Use of approved suppliers	1	1%	3%

*Table 5. – Isolated Noncompliances at TSO Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of TSO Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
508	Tool and gauge calibration	4	16%	12%
530	Nonconforming products controlled	2	8%	6%
416	Control of shelf life materials	2	8%	7%
405	Manufacturing records	2	8%	6%
611	Flow down of data to suppliers	1	4%	4%
607	Delegation of inspection to supplier	1	4%	4%
601	Use of approved suppliers	1	4%	3%
504	SPC control limits	1	4%	4%
428	Shipping of conforming products	1	4%	3%
414	Receiving inspection records	1	4%	3%
413	Receiving inspection	1	4%	3%
411	Issuance of stamps	1	4%	3%
406	Special process equipment calibrated	1	4%	4%
401	Work instructions control manufacturing process	1	4%	3%
306	Software Development Environment	1	4%	5%
207	Major design changes	1	4%	3%
206	Minor design changes	1	4%	3%
202	Technical data file	1	4%	3%
117	Internal audit results reported to management	1	4%	3%

*Table 6. – CFR-Based Noncompliances at TSO Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of CFR-Based Noncompliances</b>	<b>Percent of TSO CFR-Based Noncompliances</b>	<b>Percent with Procedures in Place</b>
408	Identification of inspection stations	3	60%	9%
401	Work instructions control manufacturing process	1	20%	3%
109	Facility relocations reported	1	20%	4%



*Table 7. – Systemic Noncompliances at PC Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of PC Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
401	Work instructions control manufacturing process	8	10%	21%
405	Manufacturing records	6	7%	16%
402	Special processes identified and defined	5	6%	14%
508	Tool and gauge calibration	4	5%	11%
424	Segregation of parts in storage	4	5%	11%
413	Receiving inspection	4	5%	11%
409	Inspection methods	4	5%	11%
602	Initial and periodic evaluation of suppliers	3	4%	10%
530	Nonconforming products controlled	3	4%	8%
416	Control of shelf life materials	3	4%	8%
529	MRB	2	2%	5%
414	Receiving inspection records	2	2%	5%
410	Inspection marking	2	2%	5%
314	Verification prior to use	2	2%	8%
313	Software security	2	2%	9%
202	Technical data file	2	2%	5%
619	Consortium activities	1	1%	6%
612	Control of supplier design	1	1%	3%
611	Flow down of data to suppliers	1	1%	3%
609	Control of direct ship suppliers	1	1%	9%
607	Delegation of inspection to supplier	1	1%	4%
534	Corrective action based on MRB	1	1%	3%
528	NDI records	1	1%	3%
521	NDI operators qualified	1	1%	3%

Criteria	Description	Number of Systemic Noncompliances	Percent of PC Systemic Noncompliances	Percent with Procedures in Place
520	NDI processes controlled	1	1%	3%
513	Test procedures controlled	1	1%	3%
509	Calibration standards	1	1%	3%
507	Tool and gauge accuracy	1	1%	3%
430	Documents to importing country	1	1%	3%
425	Incorporation of design changes	1	1%	3%
420	Traceability to split lots	1	1%	4%
415	Verification of shelf life materials	1	1%	3%
411	Issuance of stamps	1	1%	3%
408	Identification of inspection stations	1	1%	3%
311	Change documentation and approval	1	1%	4%
302	Configuration Index Document	1	1%	7%
301	Software Configuration Management Plan	1	1%	6%
201	Drawing control system	1	1%	3%
117	Internal audit results reported to management	1	1%	3%
116	Internal audit	1	1%	3%
105	Quality manual in use	1	1%	3%
103	Policy document describes organization	1	1%	3%

*Table 8. – Isolated Noncompliances at PC Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of PC Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
409	Inspection methods	6	13%	16%
401	Work instructions control manufacturing process	6	13%	15%
406	Special process equipment calibrated	5	11%	13%
202	Technical data file	3	6%	8%
530	Nonconforming products controlled	2	4%	5%
405	Manufacturing records	2	4%	5%
107	Tags, forms, etc. described	2	4%	5%
611	Flow down of data to suppliers	1	2%	3%
609	Control of direct ship suppliers	1	2%	9%
601	Use of approved suppliers	1	2%	3%
534	Corrective action based on MRB	1	2%	3%
526	NDI test samples	1	2%	3%
519	Flight check-off form	1	2%	6%
512	Tool control of NDI equipment	1	2%	3%
508	Tool and gauge calibration	1	2%	3%
501	Statistical sampling plans	1	2%	3%
423	Control of cleaners	1	2%	3%
417	Incoming material segregated	1	2%	3%
413	Receiving inspection	1	2%	3%
412	Environmental controls	1	2%	3%
404	Special process operator qualifications	1	2%	3%
403	New or changed processes approved	1	2%	3%

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of PC Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
402	Special processes identified and defined	1	2%	3%
314	Verification prior to use	1	2%	4%
312	Software problem reporting	1	2%	4%
206	Minor design changes	1	2%	3%
205	Design changes appropriately documented	1	2%	3%
201	Drawing control system	1	2%	3%

*Table 9. – CFR-Based Noncompliances at PC Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of CFR-Based Noncompliances</b>	<b>Percent of PC CFR-Based Noncompliances</b>	<b>Percent with Procedures in Place</b>
704	MMF work performed IAW approved data	1	11%	17%
534	Corrective action based on MRB	1	11%	3%
533	MRB major or minor determination	1	11%	3%
529	MRB	1	11%	3%
508	Tool and gauge calibration	1	11%	3%
425	Incorporation of design changes	1	11%	3%
206	Minor design changes	1	11%	3%
202	Technical data file	1	11%	3%
109	Facility relocations reported	1	11%	4%

Table 10. – Systemic Noncompliances at PMA Facilities

Criteria	Description	Number of Systemic Noncompliances	Percent of PMA Systemic Noncompliances	Percent with Procedures in Place
602	Initial and periodic evaluation of suppliers	13	8%	12%
413	Receiving inspection	12	7%	9%
427	Part marking	11	7%	9%
401	Work instructions control manufacturing process	10	6%	9%
601	Use of approved suppliers	9	5%	8%
206	Minor design changes	8	5%	8%
116	Internal audit	8	5%	9%
508	Tool and gauge calibration	7	4%	6%
416	Control of shelf life materials	7	4%	7%
409	Inspection methods	6	4%	5%
405	Manufacturing records	6	4%	5%
402	Special processes identified and defined	6	4%	6%
201	Drawing control system	6	4%	5%
428	Shipping of conforming products	5	3%	4%
117	Internal audit results reported to management	5	3%	6%
202	Technical data file	4	2%	3%
530	Nonconforming products controlled	3	2%	2%
513	Test procedures controlled	3	2%	3%
204	Design change approval	3	2%	3%
603	Approval of supplier's quality manual	2	1%	4%
521	NDI operators qualified	2	1%	3%
425	Incorporation of design changes	2	1%	2%
207	Major design changes	2	1%	2%
105	Quality manual in use	2	1%	2%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of PMA Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
706	Logbooks properly annotated	1	1%	3%
618	Control of parts from associate facilities	1	1%	3%
614	Quality review of purchase documents	1	1%	1%
605	Use of other party registered suppliers	1	1%	3%
529	MRB	1	1%	1%
522	NDI procedures available	1	1%	1%
511	SOT gauges	1	1%	1%
510	Protection of tools and gauges	1	1%	1%
509	Calibration standards	1	1%	1%
507	Tool and gauge accuracy	1	1%	1%
426	Storage of conforming parts	1	1%	1%
424	Segregation of parts in storage	1	1%	1%
423	Control of cleaners	1	1%	1%
422	Prevention of part damage/contamination	1	1%	1%
420	Traceability to split lots	1	1%	1%
418	Traceability of components	1	1%	1%
415	Verification of shelf life materials	1	1%	1%
414	Receiving inspection records	1	1%	1%
410	Inspection marking	1	1%	1%
404	Special process operator qualifications	1	1%	1%
310	Software Configuration Management Plan	1	1%	2%
308	Programmed media handling/storage	1	1%	2%
205	Design changes appropriately documented	1	1%	1%

<b>Criteria</b>	<b>Description</b>	<b>Number of Systemic Noncompliances</b>	<b>Percent of PMA Systemic Noncompliances</b>	<b>Percent with Procedures in Place</b>
107	Tags, forms, etc. described	1	1%	1%
102	Operating within production limitations	1	1%	1%



*Table 11. – Isolated Noncompliances at PMA Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of PMA Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
530	Nonconforming products controlled	5	8%	4%
508	Tool and gauge calibration	5	8%	4%
202	Technical data file	5	8%	4%
602	Initial and periodic evaluation of suppliers	4	6%	4%
413	Receiving inspection	3	5%	2%
405	Manufacturing records	3	5%	3%
206	Minor design changes	3	5%	3%
204	Design change approval	3	5%	3%
601	Use of approved suppliers	2	3%	2%
510	Protection of tools and gauges	2	3%	2%
501	Statistical sampling plans	2	3%	2%
426	Storage of conforming parts	2	3%	2%
416	Control of shelf life materials	2	3%	2%
106	Quality system data and changes submitted to FAA	2	3%	2%
607	Delegation of inspection to supplier	1	2%	2%
533	MRB major or minor determination	1	2%	1%
527	NDI tanks and solutions	1	2%	1%
522	NDI procedures available	1	2%	1%
520	NDI processes controlled	1	2%	1%
514	Organizational review of test procedures	1	2%	1%
428	Shipping of conforming products	1	2%	1%
427	Part marking	1	2%	1%

<b>Criteria</b>	<b>Description</b>	<b>Number of Isolated Noncompliances</b>	<b>Percent of PMA Isolated Noncompliances</b>	<b>Percent with Procedures in Place</b>
420	Traceability to split lots	1	2%	1%
414	Receiving inspection records	1	2%	1%
411	Issuance of stamps	1	2%	1%
404	Special process operator qualifications	1	2%	1%
403	New or changed processes approved	1	2%	1%
402	Special processes identified and defined	1	2%	1%
401	Work instructions control manufacturing process	1	2%	1%
314	Verification prior to use	1	2%	2%
205	Design changes appropriately documented	1	2%	1%
201	Drawing control system	1	2%	1%
112	Feedback from users	1	2%	1%
103	Policy document describes organization	1	2%	1%
102	Operating within production limitations	1	2%	1%

*Table 12. – CFR-Based Noncompliances at PMA Facilities*

<b>Criteria</b>	<b>Description</b>	<b>Number of CFR-Based Noncompliances</b>	<b>Percent of PMA CFR-Based Noncompliances</b>	<b>Percent with Procedures in Place</b>
427	Part marking	3	23%	2%
402	Special processes identified and defined	3	23%	3%
602	Initial and periodic evaluation of suppliers	1	8%	1%
519	Flight check-off form	1	8%	3%
513	Test procedures controlled	1	8%	1%
413	Receiving inspection	1	8%	1%
409	Inspection methods	1	8%	1%
207	Major design changes	1	8%	1%
202	Technical data file	1	8%	1%